



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3183-043
Job Sheet 184294



Part No: D3183-043

Job Qty: 4 ea

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/5/18

Job Tracking No:

Due Date: 10/19/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C1 IPP Rev:Pick:A 04.02.18 New issue KJ/DS IPP Rev:B Changed Mat Size 08-06-26 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	10/19/18	10/19/18	0.00	0.00	Start Up Machining-1		Kt 2018-10-25
100	Bandsaw	4 pcs	10/19/18	10/19/18	0.00	0.21	Bandsaw1		Kt 2018-10-25
110	CNC Vertical Machining	4 pcs	10/19/18	10/19/18	0.23	16.67	HAAS1-3		Kt 2018-10-25
120	QC	4 pcs	10/19/18	10/19/18	0.00	0.00	QC2 Machining-1		Kt 2018-10-25
130	QC	4 pcs	10/19/18	10/19/18	0.00	0.00	QC8 Machining-1		Kt 2018-10-25
140	Small Fab	4 pcs	10/19/18	10/19/18	0.00	0.15	Small Fab-3		Kt 2018-10-25
150	QC	4 pcs	10/19/18	10/19/18	0.00	0.00	QC5		Kt 2018-10-25
160	Packaging	4 pcs	10/19/18	10/19/18	0.00	0.00	Packaging3-1		Kt 2018-10-25
170	QC21-SA	4 Ea	10/19/18	10/19/18	0.00	0.00	QC21		Kt 2018-10-25

Part Op 100 - Cut blanks: (1.500" x 2.250") 5.500" long
Descriptions: 110 - 1-Machine D3183-3 as per Folio FA322 and Dwg D3183 Identify as D3183-3
140 - Assemble D3183-043 as per Dwg D3183.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-B1.500X2.250	17-4 SS Bar 1.50 X2.250	1.8332 ft (.4583 ea)	90-Start up Operation	
D3121-21	Bolt	8 Ea (2 ea)	140-Small Fab	
D3183-045	Bearing Assembly	8 Ea (2 ea)	140-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-B1.500X2.250	2	10	0
140-Small Fab	D3121-21	8	59	0
	D3183-045	8	9	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			

DART AEROSPACE LTD		Work Order:	184294
Description: Bracket		Part Number:	D3183-3
Inspection Dwg: D3183	Rev: C1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.190	+/-0.030	R0.190	✓		Gaborit	
R0.063	+/-0.010	R0.063	✓		Gaborit	
0.182	+/-0.010	.185	✓		Vernier	
0.070	+/-0.010	.060	✓		Vernier	
0.100	+/-0.010	.110	✓		Vernier	
Ø0.201 x 0.100	+/-0.010	.201 x .100	✓		Vernier	
0.182	+/-0.010	.185	✓		Vernier	
5.32	+/-0.030	5.325	✓		high gage	
5.036	+/-0.010	5.040	✓		high gage	
2.120	+/-0.010	2.122	✓		high gage	
1.290	+/-0.010	1.285	✓		high gage	
0.365	+/-0.010	.366	✓		Vernier	
0.218	+/-0.010	.216	✓		Vernier	
1.030	+/-0.010	1.032	✓			
1.90	+/-0.030	1.892	✓		Vernier	
1.012	+/-0.010	1.014	✓		high gage	
Ø0.201 x 0.100	+/-0.010	.201 x .100	✓		Vernier	
0.786	+/-0.010	.785	✓		Vernier	
Ø0.392	+0.002/-0.000	.393	✓		micronette	
R0.19	+/-0.030	R.190	✓		Gaborit	
3.954	+/-0.010	3.960	✓		high gage	
0.162	+/-0.010	.165	✓		Vernier	
R0.19	+/-0.030	R.190 ok	✓		Gaborit	
R0.25	+/-0.030	R.250 ok	✓		Gaborit	
4.26	+/-0.030	4.263	✓		high gage	
2.080	+/-0.030	2.060	✓			
1.155	+/-0.010	1.155	✓			
0.162	+/-0.010	.160	✓		Vernier	
0.36	+/-0.030	.360	✓			
0.615	+/-0.010	.623	✓		Vernier	
0.435	+/-0.010	.432	✓		Vernier	
0.200	+/-0.010	.198	✓		Vernier	
0.381	+/-0.010	.388	✓		Vernier	
0.032	+/-0.010	.029	✓		micronette profondeur	

Measured by:	MM	Audited by:	MM	Prototype Approval:	N/A
Date:	20/8/20/23	Date:	18/11/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3183-043	KJ/RF	
B	04.03.15	Changes as per revision C	KJ/JLM/RF	
C	06.03.09	Dwg Rev update	KJ/JLM	
D	08.01.28	0.182 dimension removed	KJEC/DD	



Container No: S121684



Part: D3183-043

Job No: 184294

Serial No/Batch: S121684

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/25/18

10/25/18